

# Work Order ID 51163

August 5, 2009 10:58:34 AM



Page 1

Item ID: D3659-1	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: CUFF					
Start Date: 08/10/2009	Start Qty: 15.00		Cust Item ID:		
Required Date: 08/21/2009	Req'd Qty: 15.00		Customer:		

## Reference:

Approvals:	Process Plan: <u>VMF</u>	Date: <u>09-08-05</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3659	Rev B								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blank 7.300" long								
110	DOOSAN LATHE	0.00							
	Doosan	0.00							
Doosan Lathe	Memo 1-Turn as per folio FA 707 & DWG D3659, <input checked="" type="checkbox"/> FOLIO REV: <u>1</u> <input type="checkbox"/> DWG REV: <u>1</u> <input type="checkbox"/> 2-Deburr as required								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	09/08/12			10	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	09/08/13			10	0		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				0.00	0.00	0.00	0.00

Q.M. 07-08-13 (10)

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Item ID: D3659-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: CUFF

Start Date: 08/10/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/8/14

(10x) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/26 HJ 10 B1 09-8-24

# Picklist Print

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Work Order ID: 51163

Parent Item: D3659-1RevB

Parent Item Name: CUFF

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6009-129RevA		Manufactured	No			100	Each	24.0000	9.4784			
Crosstube Material												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

24

34691

7

38342

17

34691

SN 08/10/07

9.5 Pt

017 3.25  
2.375

6008-150

cut off  
pauls  
only

DART AEROSPACE LTD		Work Order:	51163
Description: CnA		Part Number:	8659-1
Inspection Dwg: 8659 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

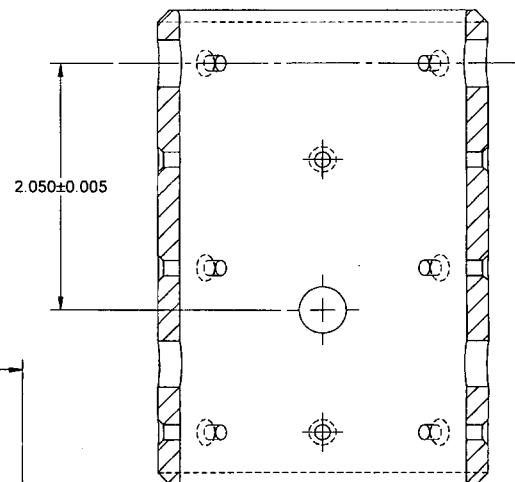
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	$\pm .010$	3.952	/			
3.075	$\pm .010$	3.075	/			
2.500	$\pm .010$	2.500	/			
1.700	$\pm .010$	1.700	/			
.800	$\pm .010$	.800	/			
.438	$\pm .010$	.444	/			
$\emptyset .128$	$\pm .006$	$\emptyset .128$	/			
G sink 230x100	$\pm .010$	.235x100	/			
$\emptyset .356$	$\pm .005$	$\emptyset .389$	/			
$\emptyset 2.740$	$\pm .005$	$\emptyset 2.740$	/			
$\emptyset 2.375$	$\pm .005$	$\emptyset 2.377$	/			
Cham-100x45	$\pm .010$	.102x45	/			

Measured by: SA	Audited by: Jnd	Prototype Approval:	N/A
Date: 05/08/11	Date: 02/08/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

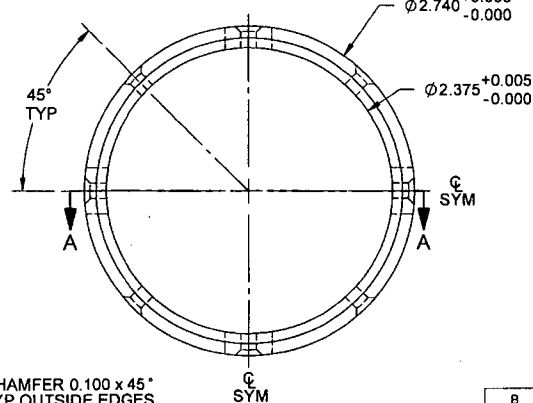
DRILL #30 (Ø 0.128 REF)  
C'SINK Ø 0.230x100°  
TYP 22 PLACES

Ø 0.386<sup>+0.005</sup>  
-0.000  
HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF,  
TYP 6 PLACES



SECTION A-A

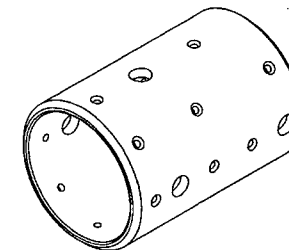
R0.032 TYP  
INSIDE EDGES



D3659-1 CUFF

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)  
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs



# 51163  
mf  
09-08-05

11-08-04 MP

B	ADD Ø 0.128 & Ø 0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	P		
CHECKED	H	DRAWING NO.	REV. B
MFG. APPR.	E	D3659	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	H	CUFF	NTS
DATE	08.03.03	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	